

Work Order ID 66811

Monday, February 28, 2011 10:42:46 AM



Page 1

Item ID: D2012-107

Accept



Setup Start



Revision ID:

Item Name: Clevis

Stop



Start Date: 2/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-02-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2012-107

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

364.063

1-Cut as per Dwg D2012-107

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

B11-3-2

(40)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-3-2

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Serials/02

counters

(x40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Abstract

Page 2

Accept

Setup Start

Stop

RESEARCH DESIGN

Cust Item ID:[illegible]

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

**Insp.
Stamp**

0.00

Abstract

NC BRAKE

Brake NC

Memo

0.00

Brake NC

Form on press using ~~DT8242~~ as per Dwg D2012-107

0.00

0.00

140

[illegible]

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150

[illegible]

Packaging

Packaging

Identify as per dwg & Stock Location: 009

Memo

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Monday, February 28, 2011 10:42:46 AM

Page 3

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Run Start

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

[illegible]

QC

Memo

0.00

Quality Control

Number Stamp
11/03/04
MF
11-03-03

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, February 28, 2011 10:42:53 AM

Page 1

Work Order ID: 66811

Parent Item: D2012-107

Parent Item Name: Clevis





Start Date: 2/28/2011

Required Date: 3/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: D 01.11.08 Re-format, Drawing to Rev. C SM
IPP Rev:E Now on Waterjet 06-06-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			110	sf	39.8400	0.016	0.336842	1.		
												1B11-3-2	

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT

39.84

111323

0

116623

39.84

116623

(40)

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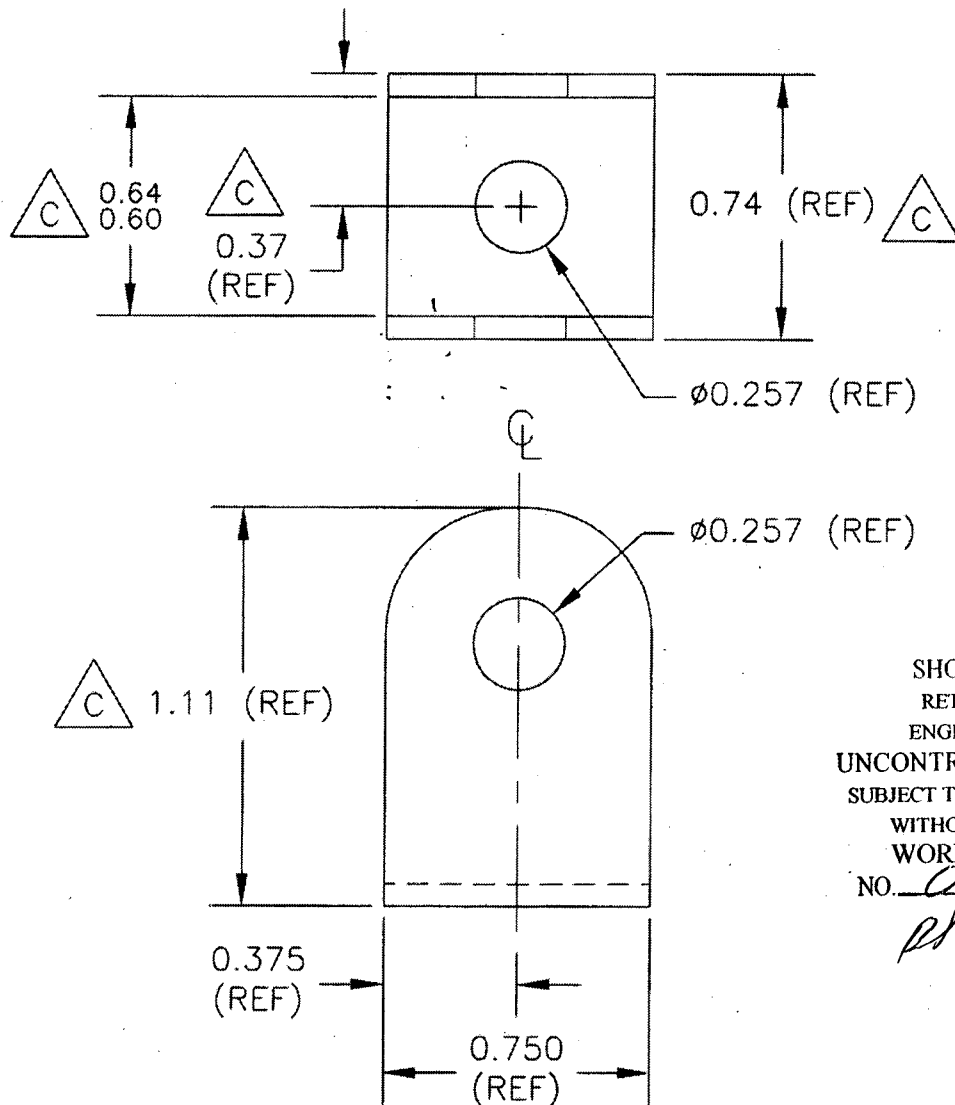
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NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-107	REV. C SHEET 1 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1
A	94.10.27	NEW ISSUE	
B	99.04.30	ADD FLAT PATTERN	
C	99.12.20	0.74 WAS 0.680	

RELEASED
00.01.04 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *6484*

2811-02-22

MATERIAL: AISI 304/316 SS 0.063 THICK
USE 0.032 BEND RADIUS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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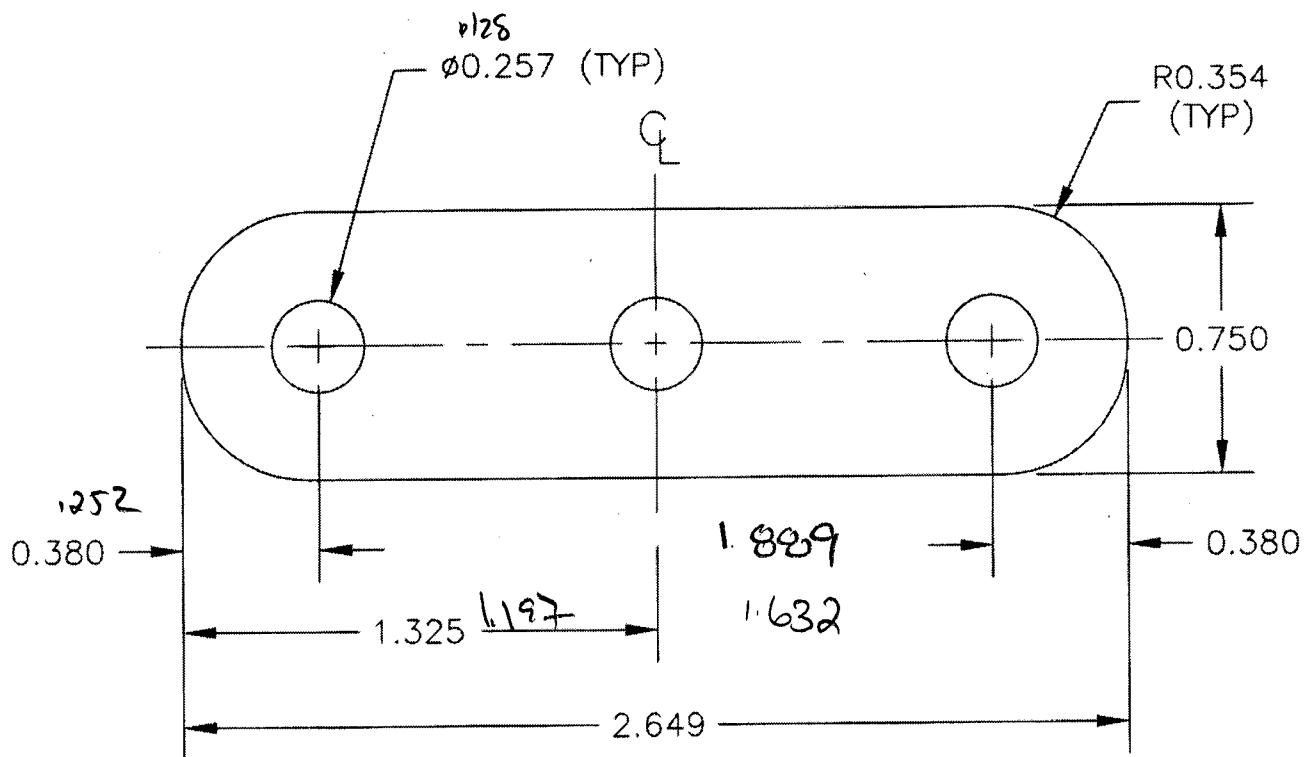
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-107	REV. C SHEET 2 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1

RELEASED
00-01-04 DS

W1066811



D2012-107 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK
TOLERANCES ARE DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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